

Work Order ID 66201

February 7, 2011 12:46:57 PM



Page 1

Item ID:	D4192-041	Accept		Setup	Start	
Revision ID:	PRELIM				Stop	
Item Name:	Adapter Plate Assembly, LH					
Start Date:	2/07/11	Start Qty:	2.00	Cust Item ID:		
Required Date:	2/18/11	Req'd Qty:	2.00	Customer:		
Reference:						

Approvals:	Process Plan:	<u>CL</u>	Date:	<u>11/02/07</u>	Tooling:		Date:		Run	Start	
	QC:		Date:		SPC (Y/N):		Date:			Stop	

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr
D4192	<u>PAT PA2</u>

100		0.00							
	BAND SAW								
Bandsaw	Memo	0.00							
Jeaspa Bandsaw	Cut Blank to 4.200"								
	Batch: <u>14252</u>								

110		0.00							
	HAAS CNC VERTICAL MACHINING #1								
HAAS 1	Memo	0.00							
HAAS CNC vertical machine #1	1-Machine per folio FA994								
	DWG REV: <u>PA2</u>								
	FOLIO REV: <u>AA</u>								

2- deburr rough edges

MATERIAL CERTIFICATION
REQ'D UPON DELIVERY



PRELIMINARY ISSUE

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 66201

February 7, 2011 12:46:57 PM



Item ID: D4192-041

Accept



Revision ID: PRELIM

Item Name: Adapter Plate Assembly, LH

Start Date: 2/07/11 Start Qty: 2.00

Required Date: 2/18/11 Req'd Qty: 2.00



Cust Item ID:

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

As
Remit
Parts To (2)
JLM.
No Bush

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
120 QC Quality Control	QC2- Inspect parts off machine FAI/FAIB Memo	0.00 0.00		B.A 11/03/22		2	0		
130 QC Quality Control	QC8- Inspect parts - second check Memo	0.00 0.00		SL 11/03/22					(2)
140 HandFinish Hand Finishing	Chemical Conversion Coat per QS1005 4.1 Memo	0.00 0.00							2 BR 11-3-22

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

[illegible]

February 7, 2011 12:46:57 PM

Accept

**Setup Start**

Stop

[illegible]**Cust Item ID:**

Required Date: 2/18/11 Req'd Qty: 2.00

Customer:

Reference:

Approvals: **Process Plan:** _____ **Date:** _____ **Tooling:** _____ **Date:** _____

Run Start

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop

Operation Description

Set Up/ Run Hours

Tool ID

Tool #

Plan Code

**Accept
Qty**

Reject
QtyReject
Number

**Insp.
Stamp**

150

QC3- Inspect Part Finish

0.00

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QC

Memo

0.00

Quality Control

160

0.00

Small Fab

Memo

0.00

Small Fab

INSTALL ANCHOR NUTS & RIVETS AS PER DWG

170

QC5- Inspect part completeness to step on W/O

0.00



OC

Memo

0.00

Quality Control

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			






NOTE: Date & initial all entries

Work Order ID 66201



February 7, 2011 12:46:57 PM





Page 4

Item ID: D4192-041 Accept  Setup Start 
Revision ID: PRELIM Stop 
Item Name: Adapter Plate Assembly, LH
Start Date: 2/07/11 Start Qty: 2.00  Cust Item ID:
Required Date: 2/18/11 Req'd Qty: 2.00  Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start 
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop 

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
180  Packaging	Identify as per dwg & Stock Location: _____ Memo	0.00 0.00							
190  QC	QC21- Final Inspection - Work Order Release Memo	0.00 0.00							
Packaging									
Quality Control									

Eagle

11-06-9

POSITIVE RECALL

EFFECTIVE 11-02-07 AUTH W

RELEASED _____ DATE _____

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

Page 1

February 7, 2011 12:46:56 PM

Work Order ID: 66201

Parent Item: D4192-041

Parent Item Name: Adapter Plate Assembly, LH

Start Date: 2/07/11

Required Date: 2/18/11

Start Qty: 2.00

Required Qty: 2.00

Comments: IPP REV:A NEW ISSUE 10-11-12 JLM VERIFIED BY:DD

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M6061T6B0.750X03.00 0		Purchased	No			100	f	53.0000	0.35	0.736842			



6061-T6 Bar .750 x 3.00

Location	Loc Qty	Loc Code
MAT02	53	
104741	21	
14252	12	
15211	20	

7369

ent 11/02/24

MS20426AD3-6-f Purchased No



Rivet

Location	Loc Qty	Loc Code
ST316	14148	M 10-1374
4179	2310	
4444	5678	
4533	6160	

16

MS21062-3K Purchased No



Nut Plate

Location	Loc Qty	Loc Code
ST302	216	
109590	216	

2

MS21061L3

M117291

Feb 11.01.05

13 ipf 903946
(1000m Edge)
Feb 11.03.22

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

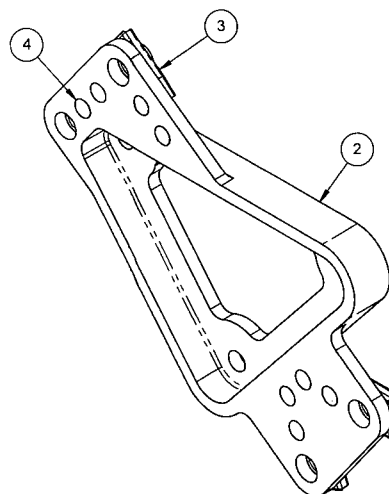
Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

ITEM NO.	QTY. -041	PART NUMBER	DESCRIPTION
1	X	D4192-041	LH ADAPTER PLATE ASSEMBLY
2	1	D4192-1	ADAPTER PLATE - LH
3	4	MS21062-3K <i>MS21061-3</i>	ANCHOR NUT
4	8	MS20426AD3-4 <i>14</i>	RIVET

Jul 11/03-28



D4192-041 LH ADAPTER PLATE ASSEMBLY

PRELIMINARY ISSUE

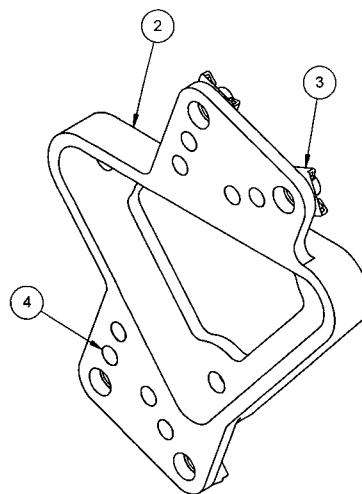
10.11.04

- NOTES:
 1) MATERIAL: N/A
 2) FINISH: N/A
 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 6) IDENTIFICATION: IDENTIFY PER QSI 044 6.1
 7) WEIGHT: 0.10 lbs

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 WITHOUT NOTICE
 WORK ORDER
 NO. *66201*
CZ1102107

PA2	NEW ISSUE		10.11.04
REV.		DESCRIPTION	BY DATE
DESIGN	<i>10</i>	DART AEROSPACE LTD	
DRAWN	<i>10</i>	HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO. D4192	REV. PA2
MFG. APPR.			SHEET 1 OF 4
APPROVED		TITLE ADAPTER	SCALE
DE APPR.			NTS
DATE	10.11.04	<small>COPYRIGHT © 2010 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small>	

ITEM NO.	QTY. -043	PART NUMBER	DESCRIPTION
1	X	D4192-043	RH ADAPTER PLATE ASSEMBLY
2	1	D4192-3-a	ADAPTER PLATE - RH
3	4	MS21062-3	ANCHOR NUT
4	8	MS20426AD3-5	RIVET



D4192-043 RH ADAPTER PLATE ASSEMBLY

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WITHOUT NOTICE
WORK ORDER
NO. 66201

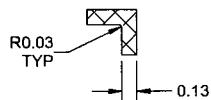
PRELIMINARY ISSUE

10.11.04

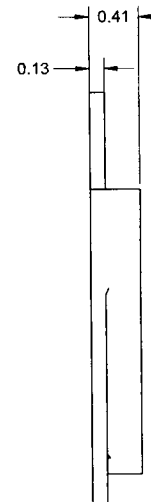
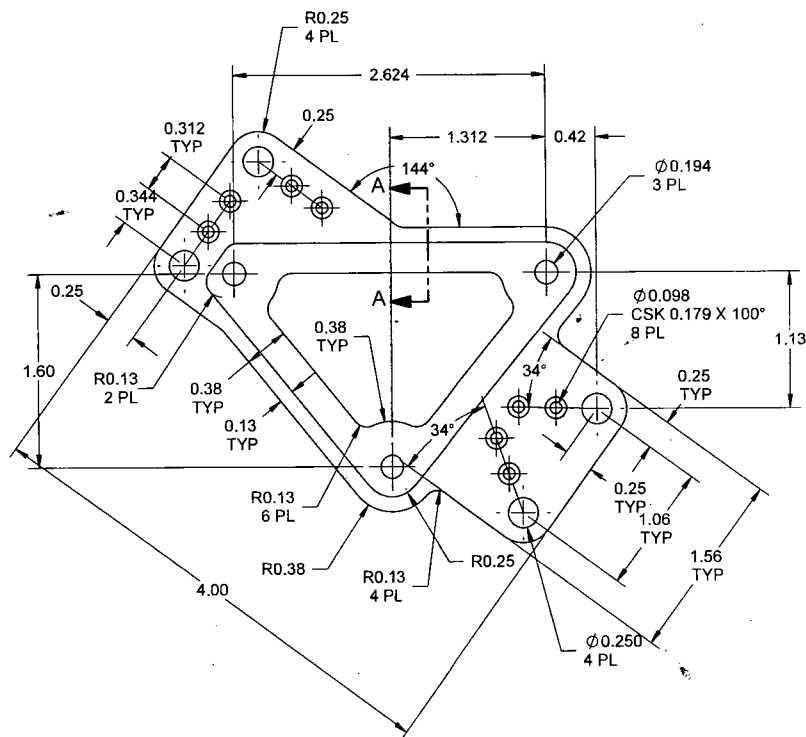
NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY PER QSI 044 6.1
- 7) WEIGHT: 0.11 lbs

DESIGN	AS	DART AEROSPACE LTD	
DRAWN	AS	HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. PA2
MFG. APPR.		D4192	SHEET 2 OF 4
APPROVED		TITLE	SCALE
DE APPR.		ADAPTER	NTS
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SECTION A-A



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WORK ORDER
NO. 66301

D4192-1 ADAPTER PLATE - LH

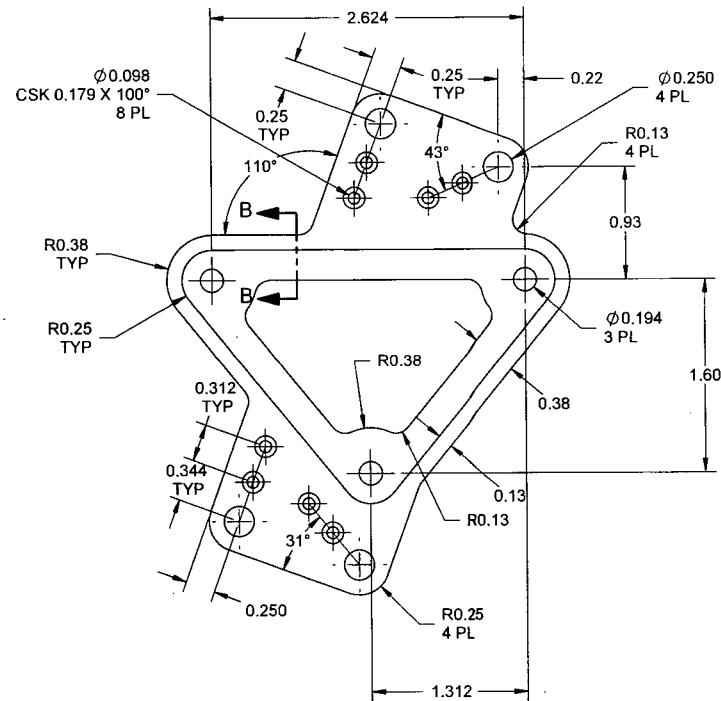
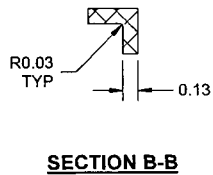
NOTES:

- 1) MATERIAL: 6061-T6/T651/T6510/T6511/T62 ALUMINUM BAR
PER QQ-A-225/8 OR AMS-QQ-A-225/8
OR AMS 4117/4128/4115/4116
OR QQ-A-200/8 OR AMS-QQ-A-200/8
OR AMS 4160
OR ASTM B211 OR ASTM B221
REF DART SPEC M6061T6B
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.09 lbs

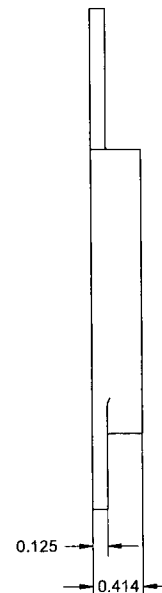
PRELIMINARY ISSUE

10.11.04

DESIGN		DART AEROSPACE LTD	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. PA2
MFG. APPR.		D4192	SHEET 3 OF 4
APPROVED		TITLE	SCALE
DE APPR.		ADAPTER	NTS
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D4192-1 ADAPTER PLATE - RH



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WITHOUT NOTICE
WORK ORDER
NO. 66201

NOTES:

- 1) MATERIAL: 6061-T6/T651/T6510/T6511/T62 ALUMINUM BAR
PER QQ-A-225/8 OR AMS-QQ-A-225/8
OR AMS 4117/4128/4115/4116
OR QQ-A-200/8 OR AMS-QQ-A-200/8
OR AMS 4160
OR ASTM B211 OR ASTM B221
REF DART SPEC M6061T6B
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.10 lbs

PRELIMINARY ISSUE
10.11.04

DESIGN		DART AEROSPACE LTD	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. PA2
MFG. APPR.		D4192	SHEET 4 OF 4
APPROVED		TITLE	SCALE
DE APPR.		ADAPTER	NTS
DATE	10.11.04	<small>COPYRIGHT © 2010 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small>	

DART AEROSPACE LTD	Work Order: 66201
Description: ADAPTER PLATE ASSEMBLY, LH	Part Number: D4192-1
Inspection Dwg: D4192 , Rev: PA2	Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☒ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
R0.03	+/- .030	R0.032	✓		R-G	ref.
0.13	+/- .030	0.123	✓		Mic	GA-03
φ0.194	+0.005 / -0.001	φ0.197	✓		Vern	GA-01
0.42	+/- .030	0.413	✓		H-G	31006
1.312	+/- .010	1.312	✓		"	"
144°	+/- 1/2°	144°	✓		Angle meter	CUC-03
0.25	+/- .030	0.251	✓		Vern	GA-01
2.624	+/- .010	2.624	✓		"	"
R0.25	+/- .030	R0.250	✓		R-G	ref.
0.312	+/- .010	0.312	✓		Vern	GA-01
0.344	+/- .010	0.344	✓		"	"
0.25	+/- .030	0.251	✓		"	"
1.60	+/- .030	1.599	✓		H-G	31006
R0.13	+/- .030	R0.125	✓		R-G	ref.
0.38	+/- .030	0.376	✓		Vern	GA-01
0.13	+/- .030	0.126	✓		"	"
R0.38	+/- .030	R0.375	✓		R-G	ref.
4.00	+/- .030	4.000	✓		Vern	GA-01
R0.13	+/- .030	R0.125	✓		R-G	ref.
φ0.250	+0.005 / -0.001	φ0.252	✓		Vern	GA-01
1.56	+/- .030	1.561	✓		"	"
1.06	+/- .030	1.060	✓		"	"
0.25	+/- .030	0.252	✓		"	"

Measured by: B.A	Audited by: SL	Prototype Approval:
Date: 11/03/22	Date: 11/03/22	Date:

Rev	Date	Change	Revised by	Approved
A		New Issue	KJ/JLM	

